

# Work Order ID 91662

**\*91662\***

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October-12-12 11:16:14 AM

Item ID: 647.1910E Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clip  
 Start Date: 10/12/12 Start Qty: 120.00 **\*120\*** Cust Item ID:  
 Required Date: 11/02/12 Req'd Qty: 120.00 **\*120\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
647.1900									
100	PURCHASING	0.00							
<b>*100*</b>									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>18110</u>								
	a) Description: EXTRUSION FOR BRACKET								
	e) Material: 7075-T6								
	f) Material certification required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg 646.9800								

CL 12/10/12 120

12/11/30 (144)

at 12/11/30

144

DAS  
14  
9-89

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ML536</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				144	0		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/12/3 AG  
 ML512-11-36

# Picklist Print

October-12-12 11:16:14 AM

Page 1

Work Order ID: 91662

Parent Item: 647.1910E

Parent Item Name: Clip

Start Date: 10/12/12

Required Date: 11/02/12

Start Qty: 120.00

Required Qty: 120.00

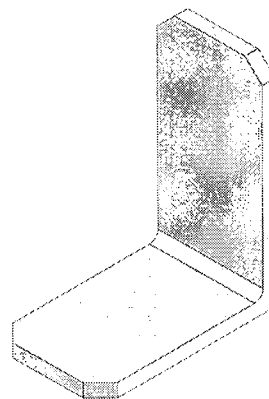
Comments: IPP REV:A NEW ISSUE 12-10-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1910P Clip		Purchased	No				f	0.0000		120		10/14/12	144

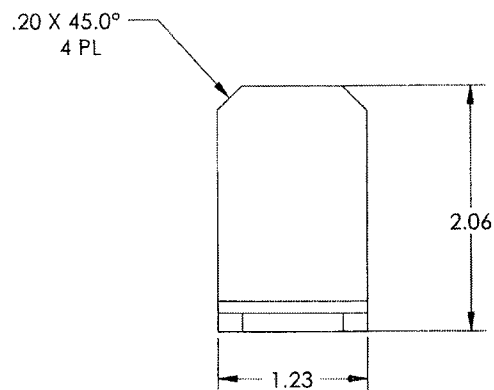
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF  
AFICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT  
THE WRITTEN PERMISSION OF AFICAL INDUSTRIES IS PROHIBITED.

NOTES:

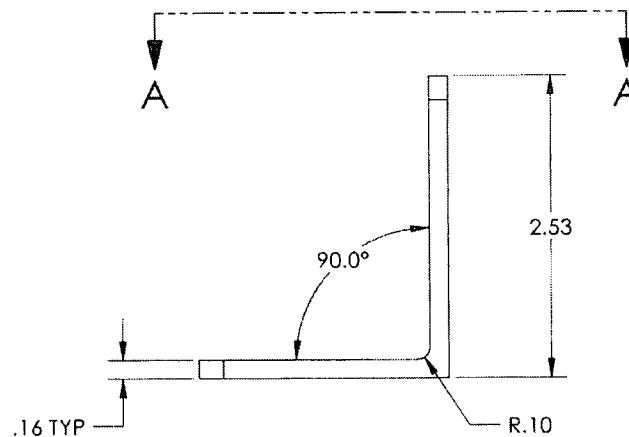
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,  
CLASS 2, COLOR BLACK;  
CARDINAL 4860-50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120



647.1910



SECTION A



W10 91662

		647.1915	SUPPORT ANGLE		
		647.1914	BRACKET		
		647.1913	TEE		
		647.1912	BRACKET, LH		
		647.1911	BRACKET, RH		
		647.1910	CLIP		
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)			APICAL INDUSTRIES		
647.1300	ORIGINAL DATE MAY-04-97		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92036-3512 (760)724-5300		
	DRAWING APPROVAL P. HAYES		BRACKETS		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS PER INCH		SCALE NONE		
	SHEET 1 OF 5		SHEET 1 OF 5		

SHIPPER NO.

405916-1

UACPART NO.

66739

**UNIVERSAL ALLOY CORPORATION**  
 180 LAMAR HALEY PKWY CANTON, GA USA 30114  
 (770) 479-7230

PRODUCTION LOTS

C554403 @12 PCS

S  
H DART AEROSPACE  
I 1270 ABERDEEN  
P HAWKESBURY, ONTARIO CN, K6A 1K7  
T  
O

S  
O DART AEROSPACE  
L 1270 ABERDEEN  
D HAWKESBURY, ONTARIO CN, K6A 1K7  
T  
O

27/320

CUSTOMER'S P.O. NO. P018110 item 3		ORDER PLACED BY LINDA LACELLE		CUSTOMER'S PART NUMBER 647.1910-EXT ALUMINUM EXTRUSION	
TERMS NET 60	ALLOY 7075 T6	SPECIFICATION NO. AMS-QQ-A-200/11 REV. N/C			
SHIP VIA JOURNEY	DATE SHIPPED 11/21/2012	FREIGHT CHARGES PREPAID <input checked="" type="checkbox"/> COLLECT <input type="checkbox"/>	SHIPMENT PARTIAL <input type="checkbox"/> COMPLETE <input checked="" type="checkbox"/>	CERTIFICATIONS ATTACHED <input checked="" type="checkbox"/> TO FOLLOW <input type="checkbox"/>	

**QUANTITY SHIPPED**

FEET	PIECES X LENGTH	NET PER PC	NET POUNDS	GROSS POUNDS	BOX
144	12 X 144.	10.33	124	175	1 bundle of 1 Standard US box
RECEIVED BY		DATE	TIME		

UNIVERSAL ALLOY CORPORATION ACCEPTS NO RESPONSIBILITY FOR ERROR IN SHIPMENT IF YOU FAIL TO NOTIFY US WITHIN 3 DAYS OF RECEIPT. NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT.

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# UNIVERSAL ALLOY CORPORATION

180 LAMAR HALEY PKWY CANTON, GA 30114 (770) 479-7230

## EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER DART AEROSPACE LTD

PURCHASE ORDER PO18110 item 3 DATE 11/12/12

ORDER NUMBER 405916 PART NO. 647.1910-EXT rev N/C

SPECIFICATIONS AMS-QQ-A-200/11 REV. N/C MATERIAL 7075-T6

### MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
C554403	L	Rear	90.6	82.2	13.1

*Handwritten:*  
DAS  
12/1/30

### MANUFACTURED IN THE U.S.A.

#### CHEMICAL COMPOSITION LIMITS

ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	TI	EACH	OTHERS	TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05		0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

PERCENT MAXIMUM UNLESS SHOWN OTHERWISE  
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

*Handwritten Signature:* Mark Briguglio  
Mark Briguglio Metallurgical Lab Manager  
QUALITY ASSURANCE DEPARTMENT



554403T04

